



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D4855-1
Job Sheet 200053



Part No: D4855-1

Job Qty: 6 pcs

DAS
21
9-30

Part Name: Antenna Bracket



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/6/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 9/30/19

Type: Stock **SOLD**

Description:

Note: DWG REV A SHEET 1 IPP REV: A NEW ISSUE JFS 13/06/26 VERIFY BY: DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	6 pcs		9/30/19	0.00	0.17	Bandsaw - 1		9/19/10/13 9/19/10/13
110	HAAS 4 Axis - B4B	6 pcs		9/30/19	0.29	5.26	HAAS - 1 - B4B		
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
130	QC 8	6 pcs		9/30/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		J.C. - 19-10-15
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		



Container No: S222415



Part: D4855-1

Job No: 200053

Serial No/Batch: S222415

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 10/15/19

Plex 9/6/19 9:59 AM Dart.lajeunesse.marie

9/6/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

140 Handfinish - 1-1 Chemical-
B4B6
pcs

9/30/19

0.00 0.24

Handfinish - 1 - 1 - B4B

Handfinish - 1 - 2 - B4B

Handfinish - 1 - 3 - B4B

Handfinish - 1 - 4 - B4B

Handfinish - 1 - 5 - B4B

Handfinish - 1 - 6 - B4B

Handfinish - 1 - 7 - B4B

Handfinish - 1 - 8 - B4B

Handfinish - 1 - 9 - B4B

Handfinish - 1 - 10 -
B4BHandfinish - 1 - 11 -
B4BHandfinish - 1 - 12 -
B4BHandfinish - 1 - 13 -
B4BHandfinish - 1 - 14 -
B4BHandfinish - 1 - 15 -
B4BHandfinish - 1 - 16 -
B4BHandfinish - 1 - 17 -
B4BHandfinish - 1 - 18 -
B4BHandfinish - 1 - 19 -
B4BHandfinish - 1 - 20 -
B4BHandfinish - 1 - 21 -
B4BHandfinish - 1 - 22 -
B4B

OCT 15 2019

150 QC 7

6
pcs

9/30/19

0.00 0.00

QC 7 - 10

QC 7 - 13

QC 7 - 14

QC 7 - 15

QC 7 - 17

QC 7 - 18

QC 7 - 19

QC 7 - 2

QC 7 - 28

QC 7 - 3

QC 7 - 30

QC 7 - 34

QC 7 - 36

QC 7 - 37

QC 7 - 41

QC 7 - 47

QC 7 - 48

QC 7 - 51

QC 7 - 58

QC 7 - 59

QC 7 - 60

QC 7 - 9

QC 7 - 68

QC 7 - 50

QC 7 - 67

QC 7 - 40

219-10-16.

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					QC 7 - 24	
					QC 7 - 43	
					QC 7 - 61	
					QC 7 - 81	
160	Powdercoat - 1 White Gl(A)- B4B	6 pcs	9/30/19	0.00 0.12	Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	
					Powdercoat - 4 - B4B	
170	QC 3	6 pcs	9/30/19	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
180	Packaging 3-1 - Stock - B4B	6 pcs	9/30/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	

BK 19-10-16

START: 1:35 OUT: 3:00 FINISH: 2:05

NOV 06 2019 10:09:59

Oscar NOV 11 2019

ST 526

				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
190 QC 21 - SA	6 12 pcs	9/30/19	0.00 0.00	QC 21 - SA - 21 ✓	ST 526
				QC 21 - SA - 70	
				QC 21 - SA - 53	

NOV 11 2019

Part Op 100 - (Bandsaw) CUT BLANK AT 3.000"
 Descriptions: 110 - (HAAS CNC Vertical Machine) 1-Machine per folio FB200
 130 - (QC8- Inspect parts - second check)
 140 - (Chemical Conversion Coat per QSI005 4.1)
 150 - (QC7-Inspect Chemical Conversion Coat)
 160 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: _____
 170 - (QC3- Inspect Part Finish)
 180 - (Identify as per dwg & Stock Location: _____)
 190 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B4.500X4.500	6061-T6 Aluminumbar 4.500" X 4.500" (CUT IN SECTION 6ft)	1.5000 ft (.25 ea)	100-Bandsaw - 1	5121732 1/2 Used.

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M6061T6B4.500X4.500	2	11	0

Used => 3.104 ft.
 BOM => 3.000 ft.
 Scrap 0.104 ft.

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Antenna Bracket	0.875Inches $\pm$ 0.010	0.885 0.865	0.875	
2	Antenna Bracket	0.201Inches $\pm$ 0.005 - 0.001	0.206 0.200	0.202	Diameter
3	Antenna Bracket	0.970Inches $\pm$ 0.030	1.000 0.940	0.970	
4	Antenna Bracket	0.970Inches $\pm$ 0.030	1.000 0.940	0.970	
5	Antenna Bracket	1.880Inches $\pm$ 0.030	1.910 1.850	1.880	
6	Antenna Bracket	3.750Inches $\pm$ 0.030	3.780 3.720	3.750	
7	Antenna Bracket	0.250Inches $\pm$ 0.030	0.280 0.220	0.250	Radius
8	Antenna Bracket	0.257Inches $\pm$ 0.005 - 0.000	0.262 0.257	0.257	Diameter
9	Antenna Bracket	2.130Inches $\pm$ 0.030	2.160 2.100	2.125	
10	Antenna Bracket	1.400Inches $\pm$ 0.030	1.430 1.370	1.400	
11	Antenna Bracket	1.260Inches $\pm$ 0.030	1.290 1.230	1.260	
12	Antenna Bracket	1.880Inches $\pm$ 0.030	1.910 1.850	1.880	
13	Antenna Bracket	0.280Inches $\pm$ 0.006 - 0.001	0.286 0.279	0.280	Diameter
14	Antenna Bracket	0.380Inches $\pm$ 0.030	0.410 0.350	0.380	Radius
15	Antenna Bracket	0.380Inches $\pm$ 0.030	0.410 0.350	0.380	Radius
16	Antenna Bracket	0.250Inches $\pm$ 0.030	0.280 0.220	0.250	Radius
17	Antenna Bracket	0.250Inches $\pm$ 0.010	0.260 0.240	0.250	
18	Antenna Bracket	2.500Inches $\pm$ 0.030	2.530 2.470	2.500	
19	Antenna Bracket	0.250Inches $\pm$ 0.010	0.260 0.240	0.251	
20	Antenna Bracket	4.250Inches $\pm$ 0.030	4.280 4.220	4.250	
21	Antenna Bracket	0.250Inches $\pm$ 0.030	0.280 0.220	0.250	Radius

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DAS
73
9-89 19-10-12

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____		DISPOSITION Rework ☐ ☐ ☐ Scrap ☐ ☐ ☐ Use-as-is ☐ ☐ ☐		DEPARTMENT/PROCESS Skid-tube ☐ ☐ ☐ ☐ ☐ Machining ☐ ☐ ☐ ☐ ☐ Large Fab ☐ ☐ ☐ ☐ ☐ Cross tube ☐ ☐ ☐ ☐ ☐ Small Fab ☐ ☐ ☐ ☐ ☐ Finishing ☐ ☐ ☐ ☐ ☐ Eng. (Non-AW) ☐ ☐ ☐ ☐ ☐ Prod. Eng. Coord. ☐ ☐ ☐ ☐ ☐ Rec/Store/Packaging ☐ ☐ ☐ ☐ ☐ Engineering ☐ ☐ ☐ ☐ ☐ Water Jet ☐ ☐ ☐ ☐ ☐ Supplier ☐ ☐ ☐ ☐ ☐ Quality ☐ ☐ ☐ ☐ ☐		MRB (QS042)																													
Date : _____		Sequence #: _____		QTY Affected : _____		MRB (QS042)																													
Description Work Order Deviation				Disposition																															
Completed By				Lead hand / Supervisor																															
				QC / QA Coordinator																															

Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY <table border="1"> <tr> <td>Pressure/Forced</td> <td>Contamination</td> <td>Power Loss/Surge</td> <td>Positioned Wrong</td> </tr> <tr> <td>Bending</td> <td>Misaligned/off center</td> <td>Folio/Program</td> <td>Outside Tolerance</td> </tr> <tr> <td>Crushing</td> <td>BOM/Route</td> <td>Grain Direction</td> <td>Drawing</td> </tr> <tr> <td>Cracks</td> <td>Broken/Damage/Defect</td> <td>Weld</td> <td>Finish</td> </tr> <tr> <td>Crimp/Kink/Ripple/Wave/Twist</td> <td>Incomplete/Unclear Instructions</td> <td>Wrong Stock Pulled</td> <td>Part Lost/Missing</td> </tr> <tr> <td>Marks/Chatter</td> <td>Drill Holes</td> <td>Out of Sequence</td> <td>Mistread</td> </tr> <tr> <td>Mislabeled</td> <td>Fit/Function</td> <td>Off-set/Set-up</td> <td></td> </tr> </table>						Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong	Bending	Misaligned/off center	Folio/Program	Outside Tolerance	Crushing	BOM/Route	Grain Direction	Drawing	Cracks	Broken/Damage/Defect	Weld	Finish	Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing	Marks/Chatter	Drill Holes	Out of Sequence	Mistread	Mislabeled	Fit/Function	Off-set/Set-up	
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